REV	DATE		REVISION HISTORY DESCRIPTION		AUTHOR	CHECKED BY	APPROVE
Α	10/03/17		INITIAL RELEASE		EW	LS	JT
В	12/20/17		TABLE, SHT 3 CHANGED BOLT DIRECTION TO FOR -2 INSTALLATION, DETAIL Q MOVE		EW	LS	JT
С	1/8/19	UPDATED LIGHTNING BON	NDING TEST VALUE; ADDED SHT 2&10; U	PDATED SECTION VIEW ID'S	CMK	LS	CMK
D	2/25/19	ADDED NOTE 16; MOVED SE	IGHT CHANNEL GEOMETRY; ADDED GAP CCTION LINE E-E RIGHT ONE FASTENER (HT 9; ADDED DETAILED ATTACHMENT PO 11	ON SHT 4; ADDED INDIVIDUAL	СМК	LS	СМК
E	11/13/20	NOTE 13- UPDATED DETAIL V ADDED SHT 5 WITH -1 DOUBLER 13); ADDED EXPLODED VIEWS C208ELP-2155-21/22/23; C NAS1580C3T10 TO NAS1580C MODIFICATION LIMITS; ADD PENETRATION DETAILS WITH O	5 IN TO 0.03 IN; ADDED NOTE 17; ADDED IN TO 0.03 IN; ADDED NOTE 17; ADDED IN NUMBER IN INSTALLATION DETAILS; UPDATED -1 INSTALLATION DETAILS; UPDATED AND AND SECTION VIEWS H1-H1 & DED DETAIL CU AND SECTION CY-CY WITCH CONTROL CONT	G; ADDED F.S. 228 DOUBLERS; & -2 SECTION FORMAT (SHTS 6 & NGLES C208ELP-2155-11/12 TO NAS1149D0632J; CHANGED H2-H2 WITH HOBBS BRACKET TH ELEVATOR CONTROL TUBE BLERS TO F.S. 128 LS & F.S. 158	СМК	LS	СМК

NOTES:

1 TRIM END OF CHANNEL BEAMS TO LENGTH AS REQUIRED, GAP BETWEEN CHANNEL AND BULKHEAD NOT TO EXCEED 0.03 IN. ADD 0.25 ± .06 RADIUS TO BOTTOM EDGE OF TRIMMED FACE.

a. APPLY PROTECTIVE FINISH TO BARE MATERIAL AS FOLLOWS: PREP SURFACE PER MIL-DTL-5541F USING

MIL-DTL-81706B CLASS 1A SURFACE TREATMENT PER MFR'S INSTRUCTIONS.

b. FINISH USING MIL-PRF-23377J TYPE 1, CLASS N OR MIL-PRF-85582D TYPE 1 PRIMER, MIL-85285D TYPE 1 OPTIONAL.

FINISH PER MFR'S INSTRUCTIONS AS APP'L.

2. MATCH DRILL Ø0.191 +0.003 / -0.000 .

a. SPOT FINISH PER NOTE 1 a. ASSEMBLE, TEST USING CALIBRATED S/B MILLIOHM METER: RESISTANCE OF INDIVIDUAL JUNCTIONS NOT TO EXCEED 2.5 S/B MILLIOHM (0.0025 OHM), FINISH PER NOTE 1 b.

/3. PREDRILLED HOLE.

4. SEAL USING MIL-S-8802F CLASS B2 SEALANT.

REF. DETAIL BW, REMOVE EXISTING BULKHEAD ATTACH RIVETS IN CONFLICT WITH RAILS INST'N. REPLACE

USING DOUBLE FLUSH NAS1097AD4-8 RIVETS WITH Ø0.179-X-100° C'SINK AT SPACING EQUAL TO OR LESS THAN EXISTING RIVET SPACING.

6. MATCH DRILL Ø0.375 +0.003 / -0.000 2a

ADJUST UNDER NUT WASHER THICKNESS/ QUANTITY AS REQUIRED TO ACCOMODATE FASTENER GRIP LENTH.

NOT APPLICABLE WHERE NOTE 9 IS INDICATED.

79. TRIM WASHERS AS NEEDED TO CLEAR EXISTING STRUCTRE AND FASTENERS.

TRIM LIGHTENING HOLE FLANGE TO PROVIDE NO GREATER THAN 1/8 inch CLEARANCE FROM INSTALLED CHANNEL OR DOUBLER.

1 TORQUE NAS1580C3 SCREWS 75-80 IN-LB. PLUS LOCKNUT DRAG. TORQUE AN6 BOLTS 160-180 IN-LB. PLUS LOCKNUT DRAG. INSTALL RIVETS IN ACCORDANCE TO MIL-R-47196A(MI).

12. NOT USED

SPOT BURNISH CONTACT AREAS TO BARE METAL PER ARP1870. FINISH AND TEST PER NOTE 2a. TEST AS SHOWN IN DETAILS CM AND CV.

 $\sqrt{14}$. Measurement taken from nearest point to nearest point considering curvature of belly pan

CONNECT CENTER POINT BETWEEN AFT JACK POINTS TO NOSE JACK POINT TO CREATE CENTERLINE

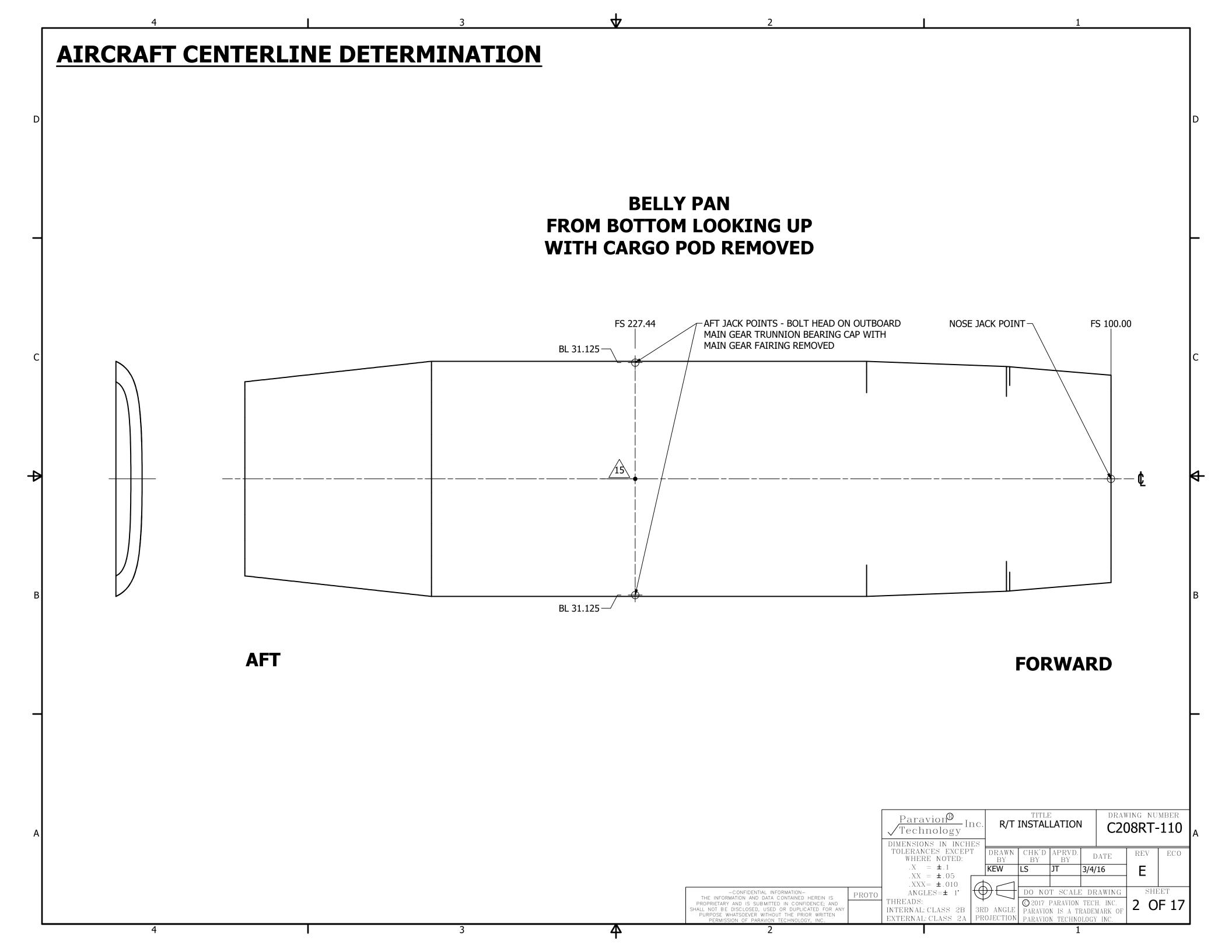
MAINTAIN 2D (2 TIMES DIAMETER OF HOLE) MINIMUM EDGE DISTANCE FOR RIVET INSTALLATION.

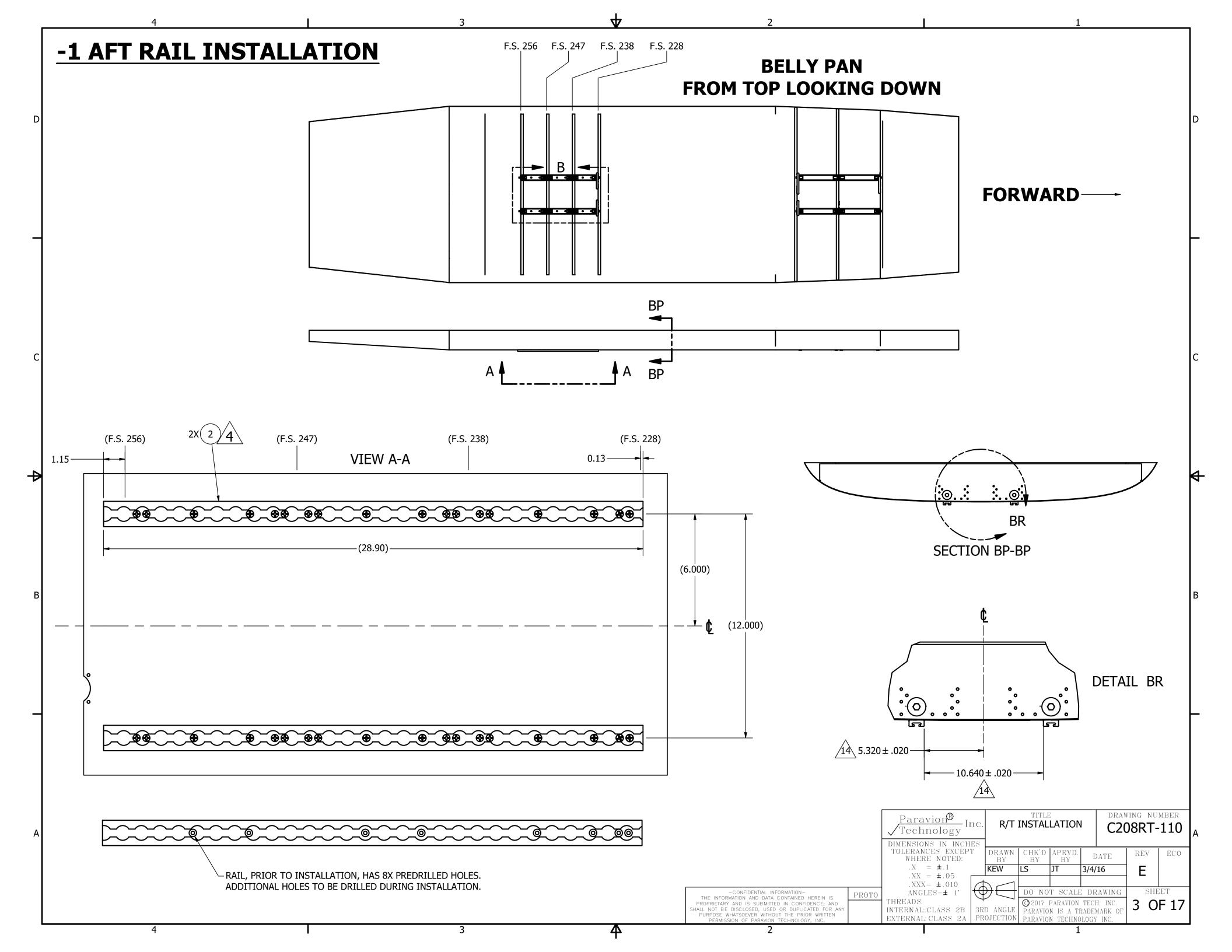
SHIM AS REQUIRED USING C208ELP-2230-1 TO ENSURE MAXIMUM 0.005 INCH CLEARANCE BETWEEN AIRCRAFT BULKHEAD FLANGE AND C208ELP-2150-X CHANNEL.

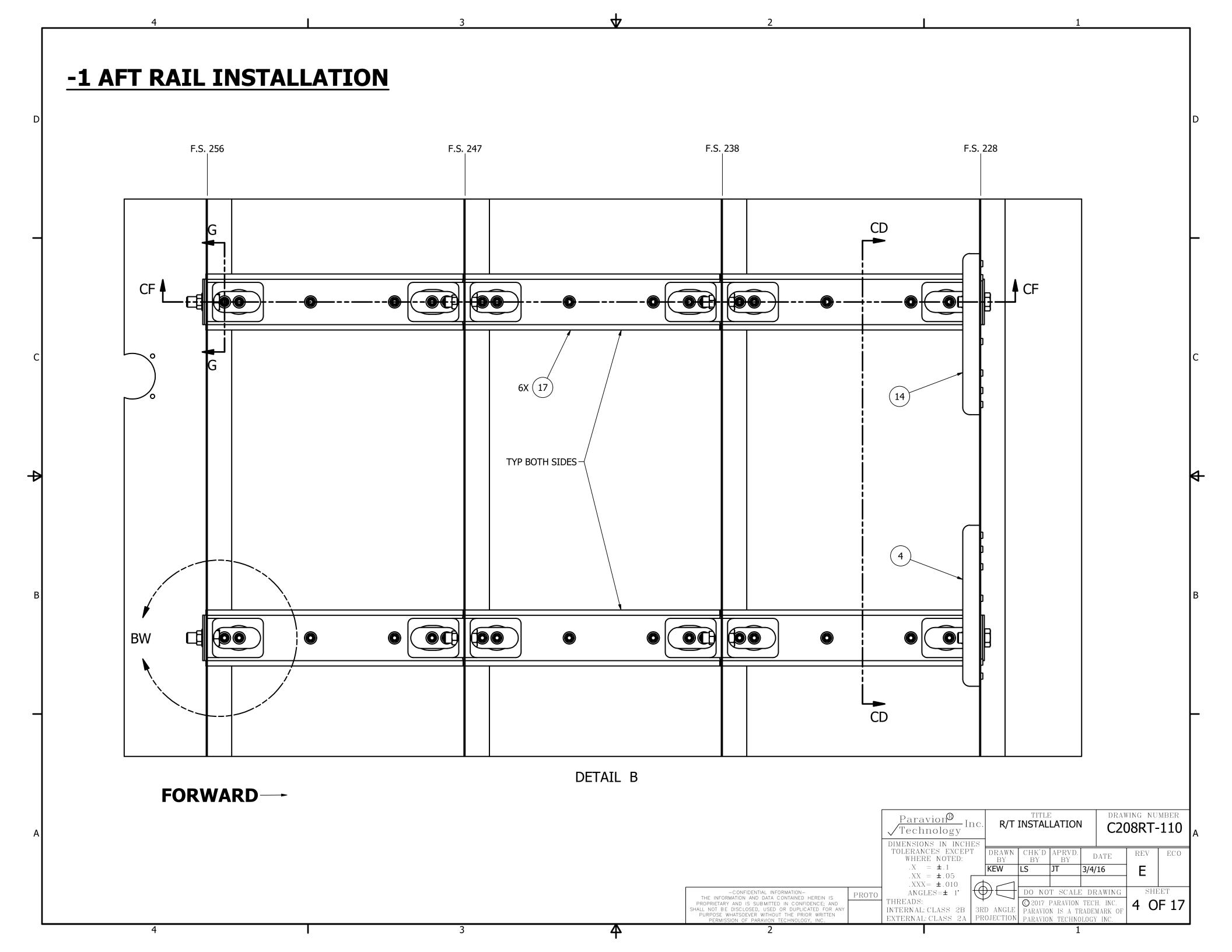
DRAWING NUMBER <u>Paravion</u>® R/T INSTALLATION C208RT-110 /Technology DIMENSIONS IN INCHES TOLERANCES EXCEPT DRAWN CHK'D APRVD. BY BY BY REV ECO DATE WHERE NOTED: $.X = \pm .1$ KEW 3/4/16 |LS $.XX = \pm .05$.XXX= ±.010 ANGLES=± 1 DO NOT SCALE DRAWING SHEET THREADS: © 2017 PARAVION TECH. INC. 1 OF 17 INTERNAL: CLASS 2B 3RD ANGLE | PARAVION IS A TRADEMARK OF PROJECTION PARAVION TECHNOLOGY INC. EXTERNAL: CLASS 2A

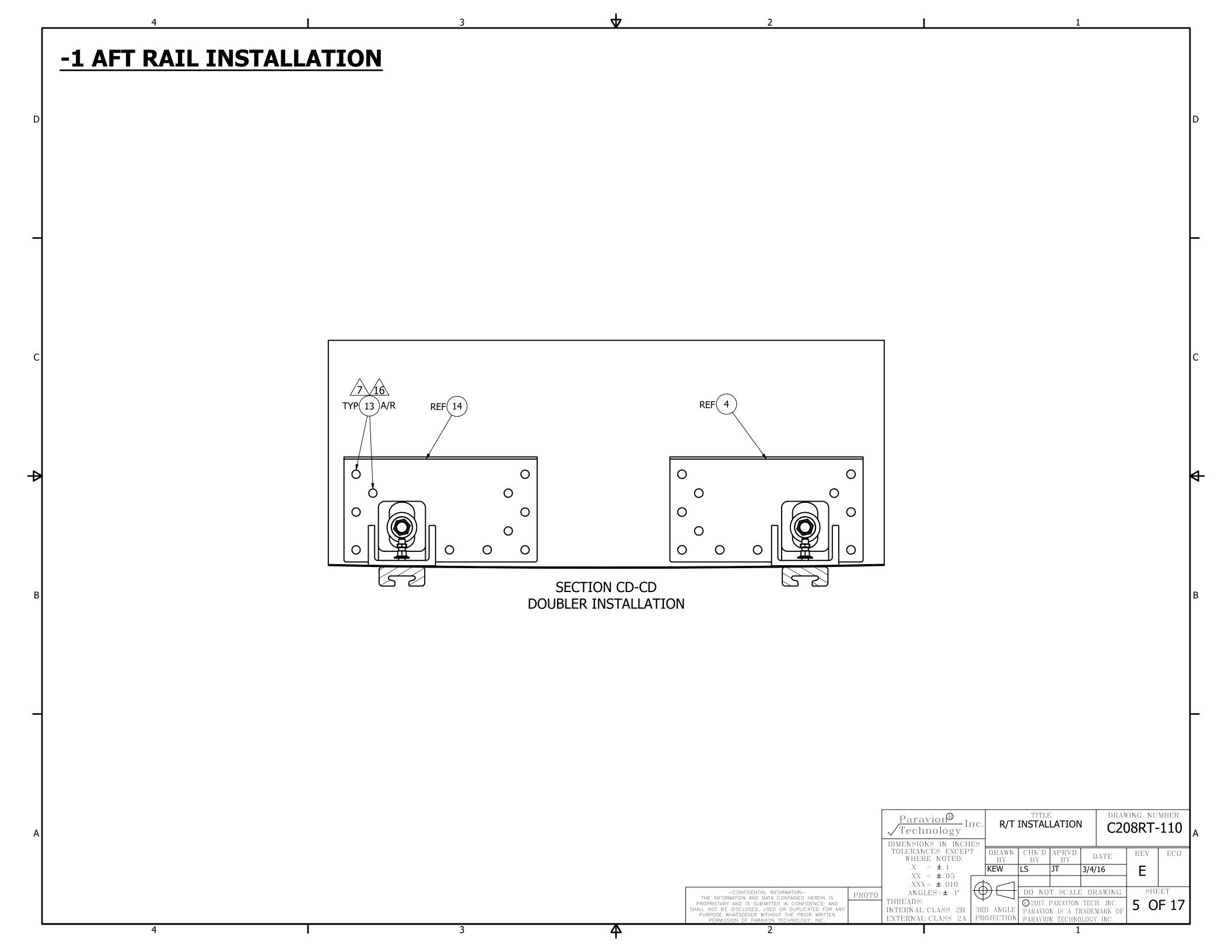
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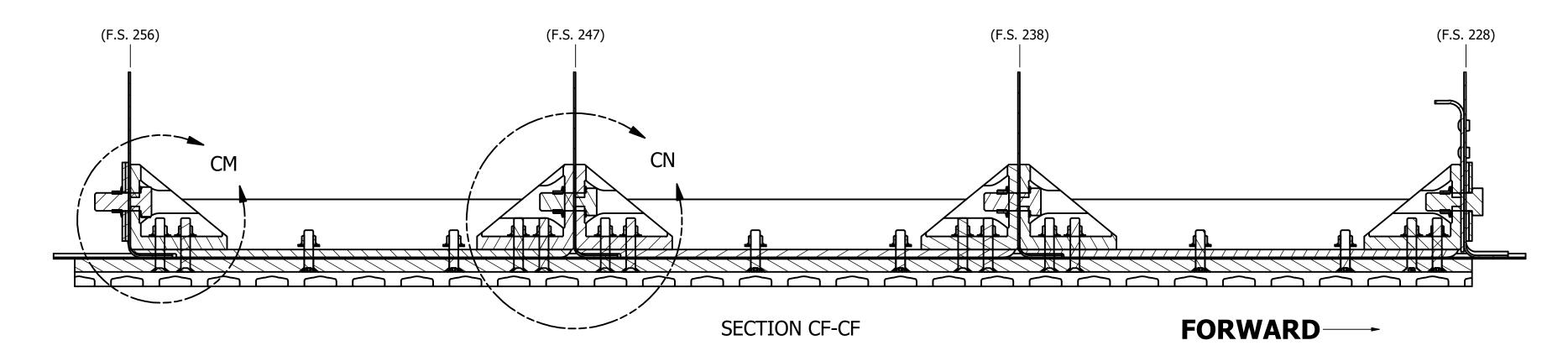




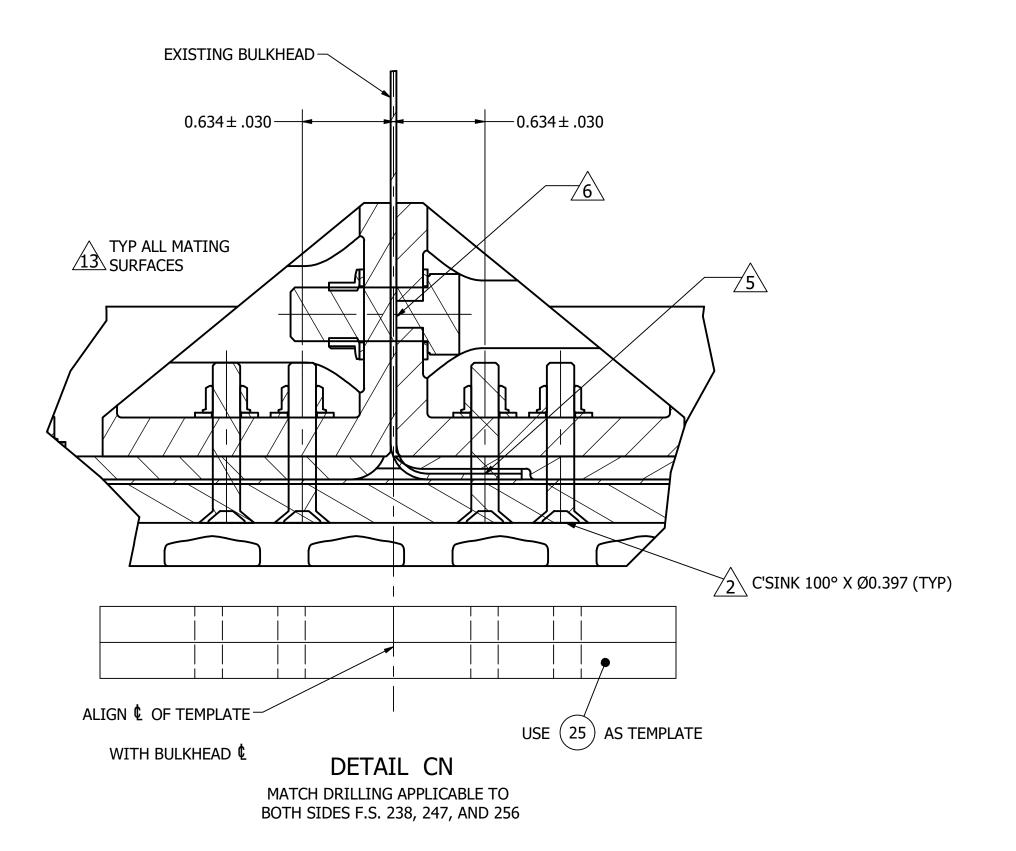
-1 AFT RAIL INSTALLATION

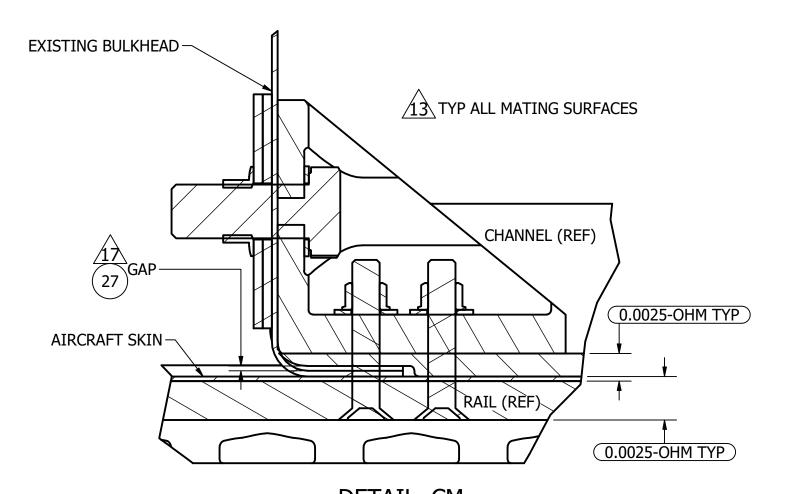
INSTALLATION MUST BE TESTED AFTER ASSEMBLY TO VERIFY ELECTRICAL BONDING. USING CALIBRATED MILLIOHM METER, TEST RESISTANCE BETWEEN THE FOLLOWING METAL-TO-METAL INTERFACES:

- LEFT CHANNEL TO NEAREST INTERNAL AIRCRAFT PRIMARY STRUCTURE (TYP), NOT TO EXCEED 2.5 MILLIOHM (0.0025 OHM). RIGHT CHANNEL TO NEAREST INTERNAL AIRCRAFT PRIMARY STRUCTURE (TYP), NOT TO EXCEED 2.5 MILLIOHM (0.0025 OHM). LOAD RAIL TO NEAREST EXTERNAL AIRCRAFT STRUCTURE (TYP), NOT TO EXCEED 2.5 MILLIOHM (0.0025 OHM).



4

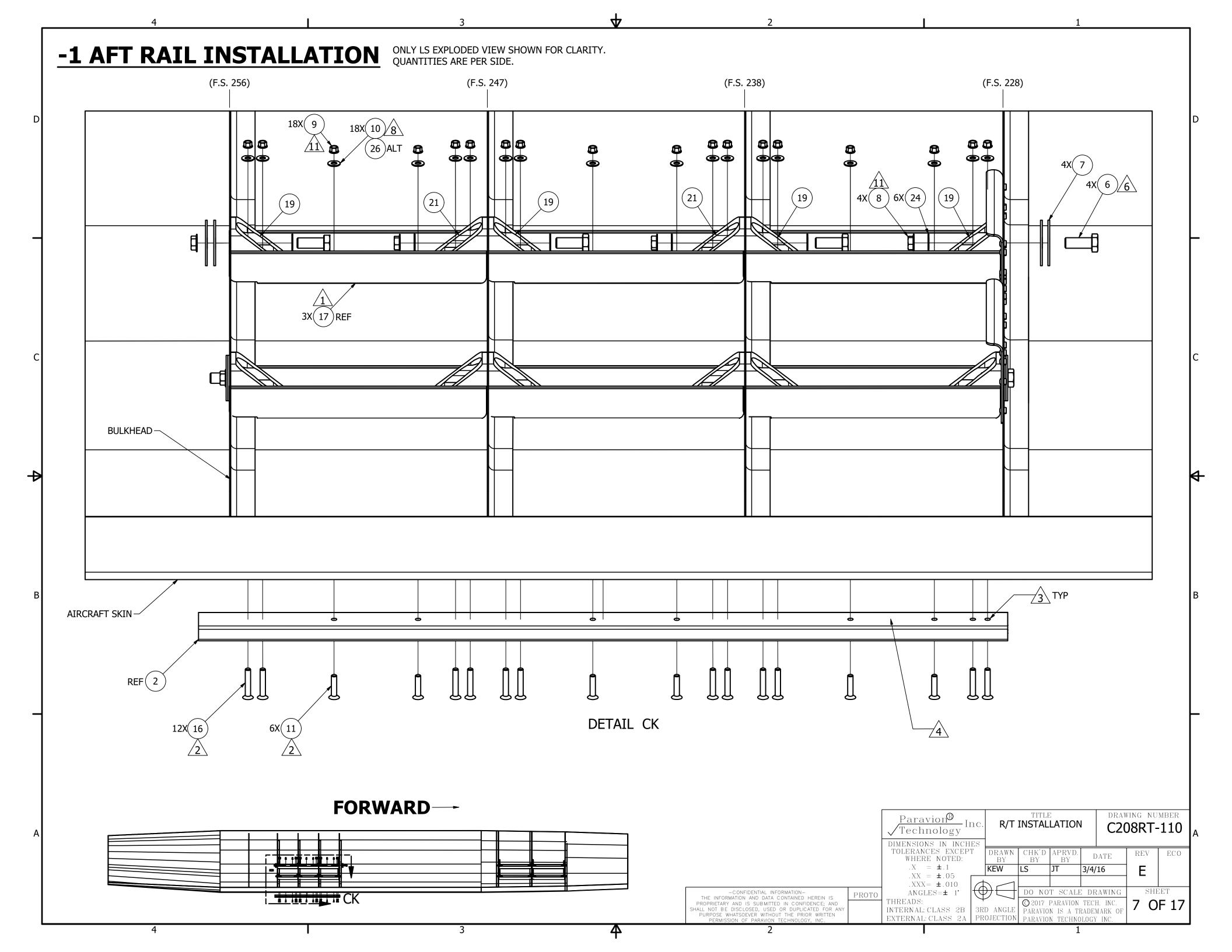


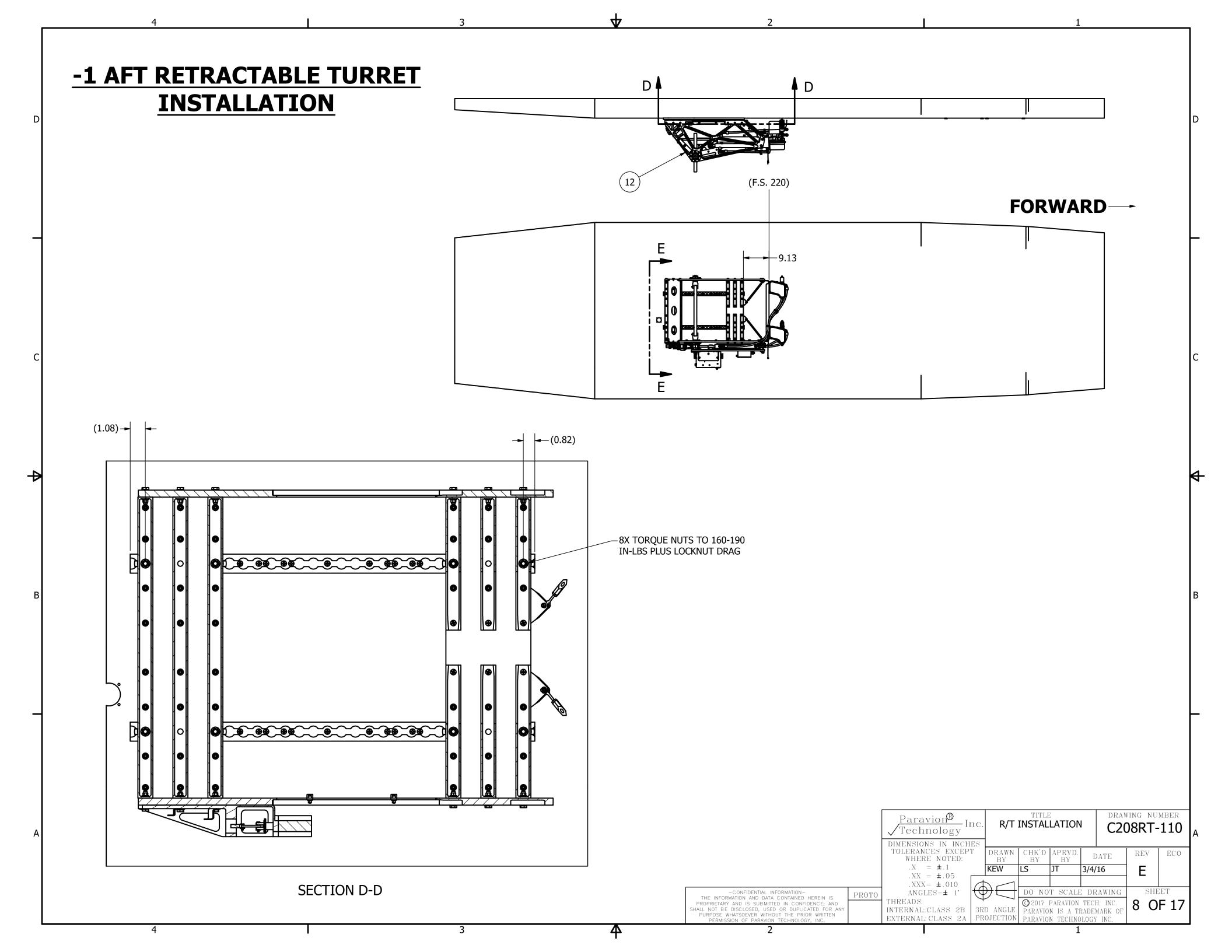


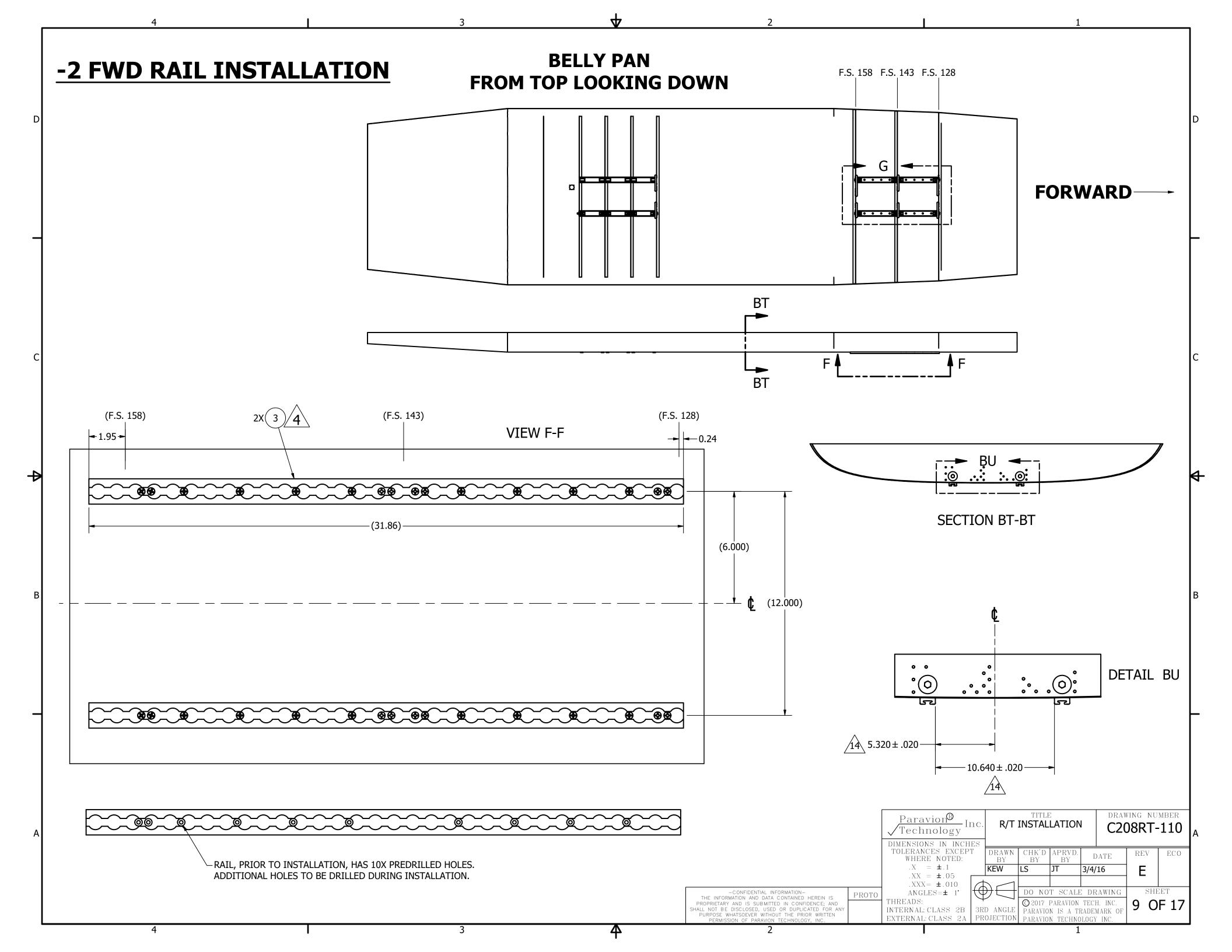
DETAIL CM SHIM AND BONDING TESTS APPLICABLE TO BOTH SIDES F.S. 228, 238, 247, AND 256

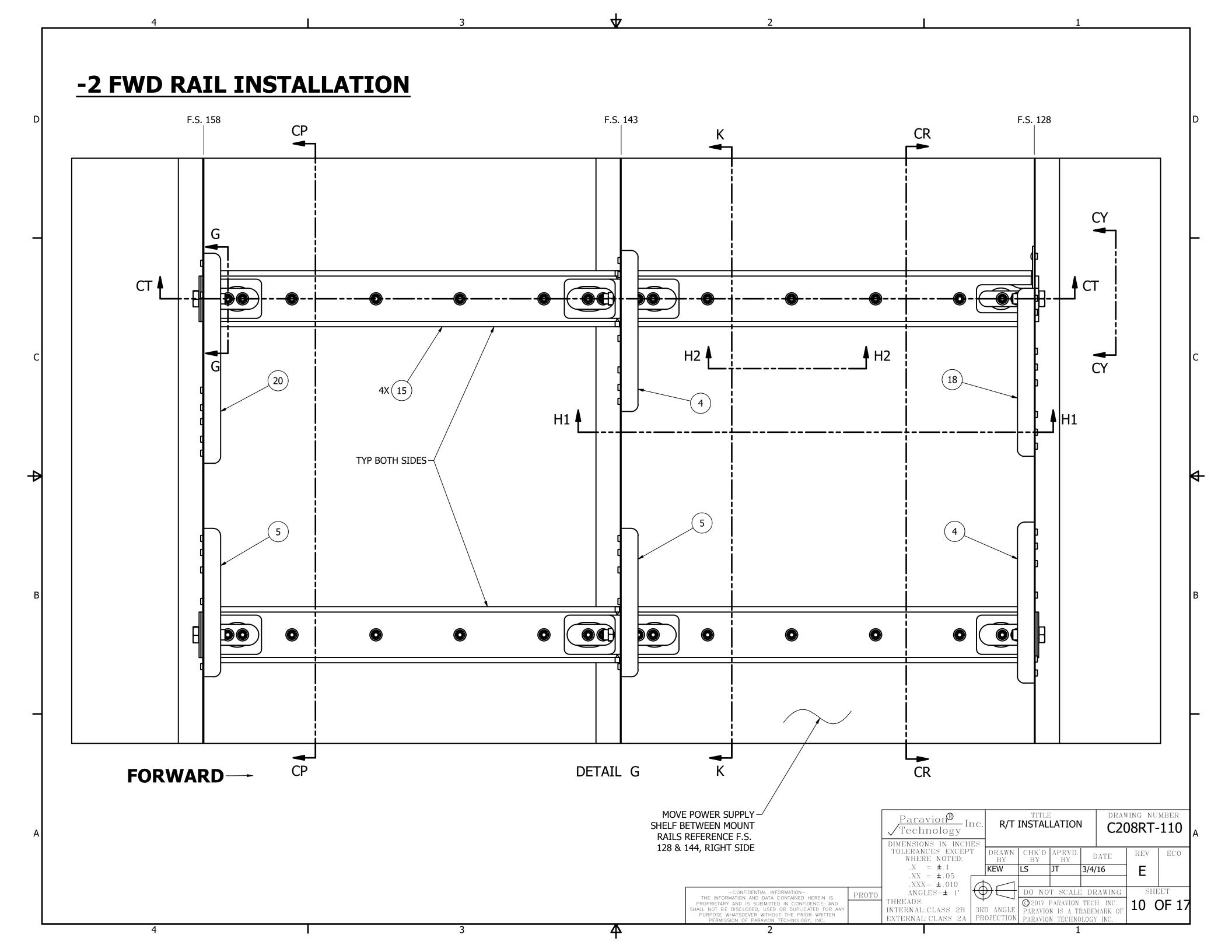
-CONFIDENTIAL INFORMATIONTHE INFORMATION AND DATA CONTAINED HEREIN IS
PROPRIETARY AND IS SUBMITTED IN CONFIDENCE; AND
SHALL NOT BE DISCLOSED, USED OR DUPLICATED FOR ANY
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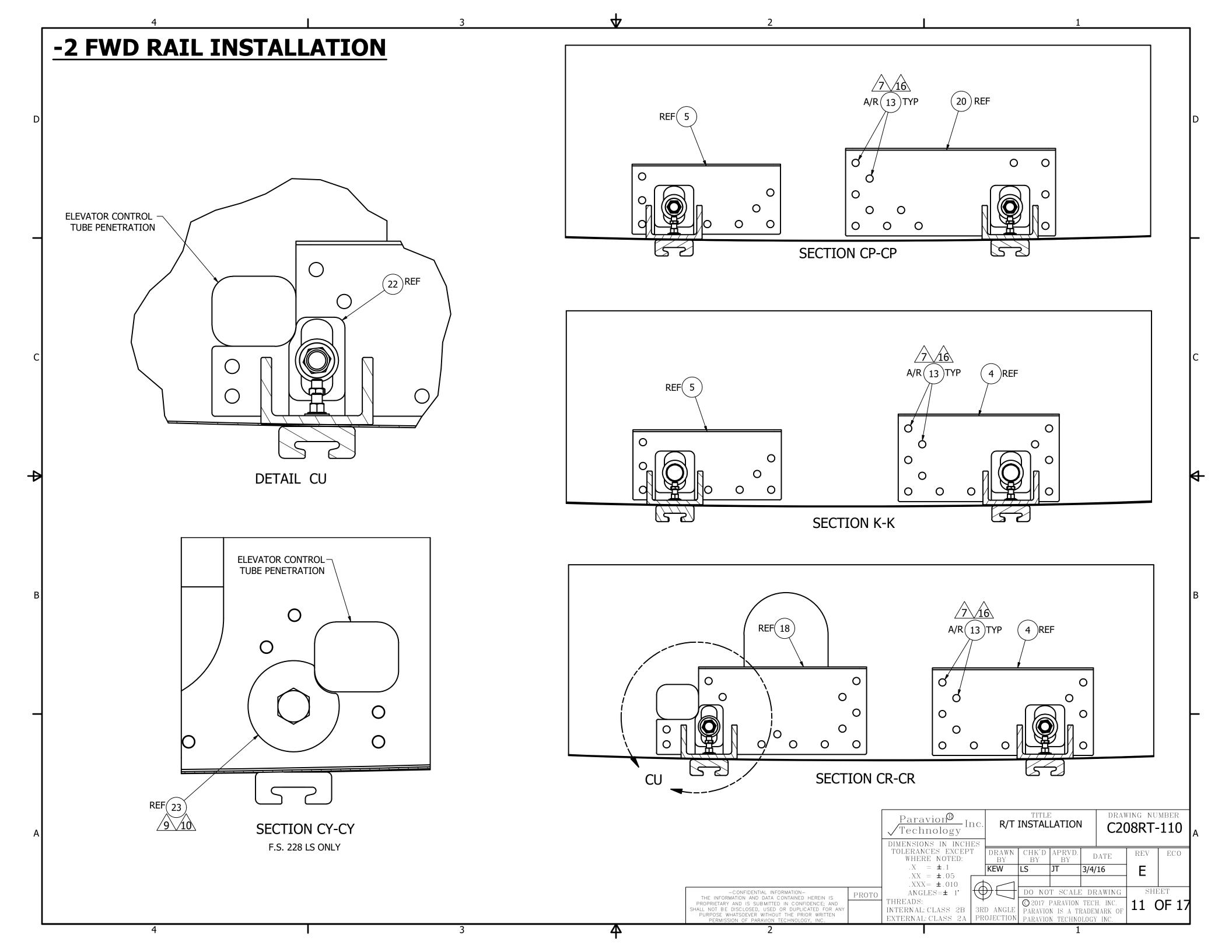
	Paravion [®] Technology	R/T INSTALLATION			DRAWING NUMBER C208RT-110				
	DIMENSIONS IN INCH TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX= ±.010		DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	3/4/) ATE	REV	ECO
ТО	ANGLES=± 1' THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A	3RI PR	D ANGLE OJECTION		11 10 21 11	TECI RADE!	H. INC. Mark of	6 O	ЕТ F 17

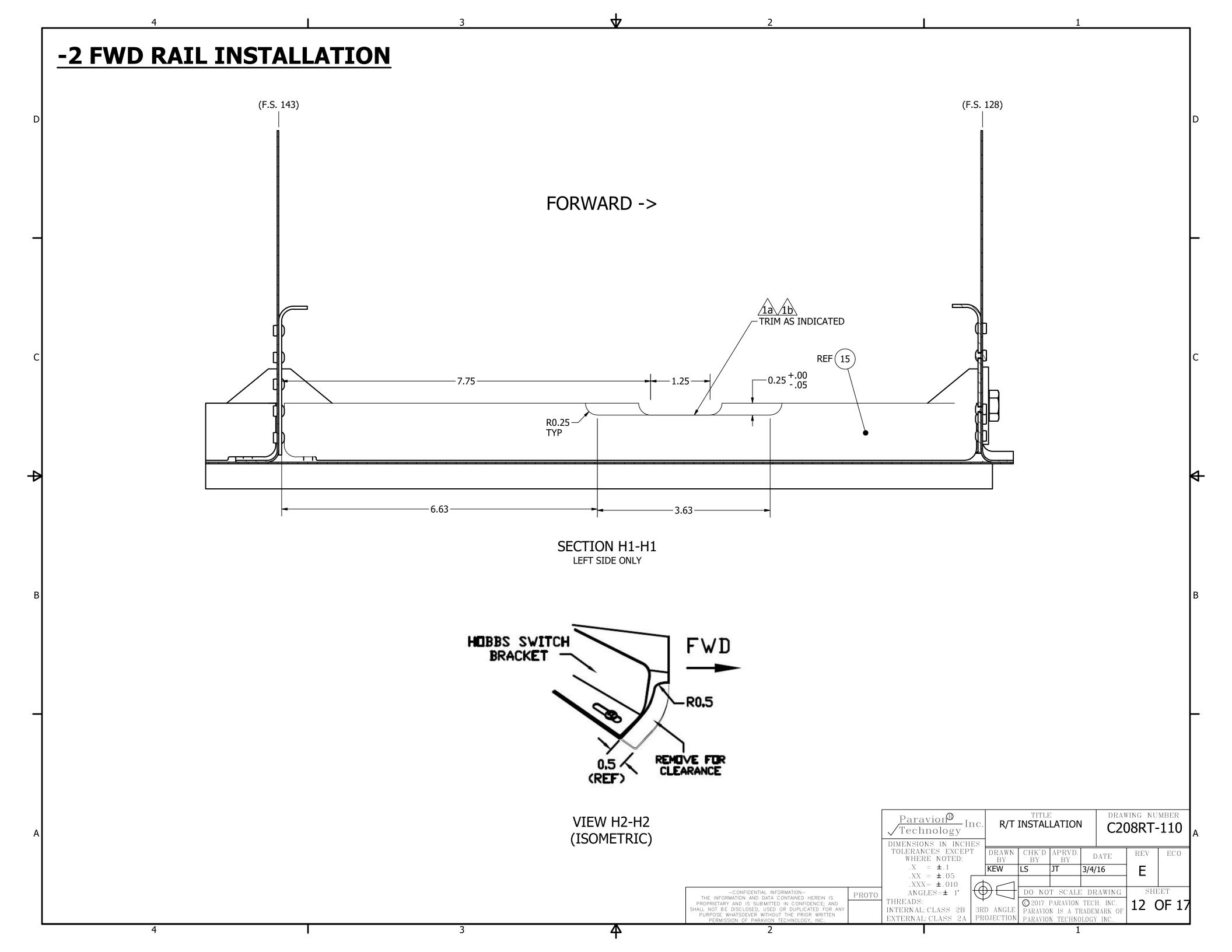


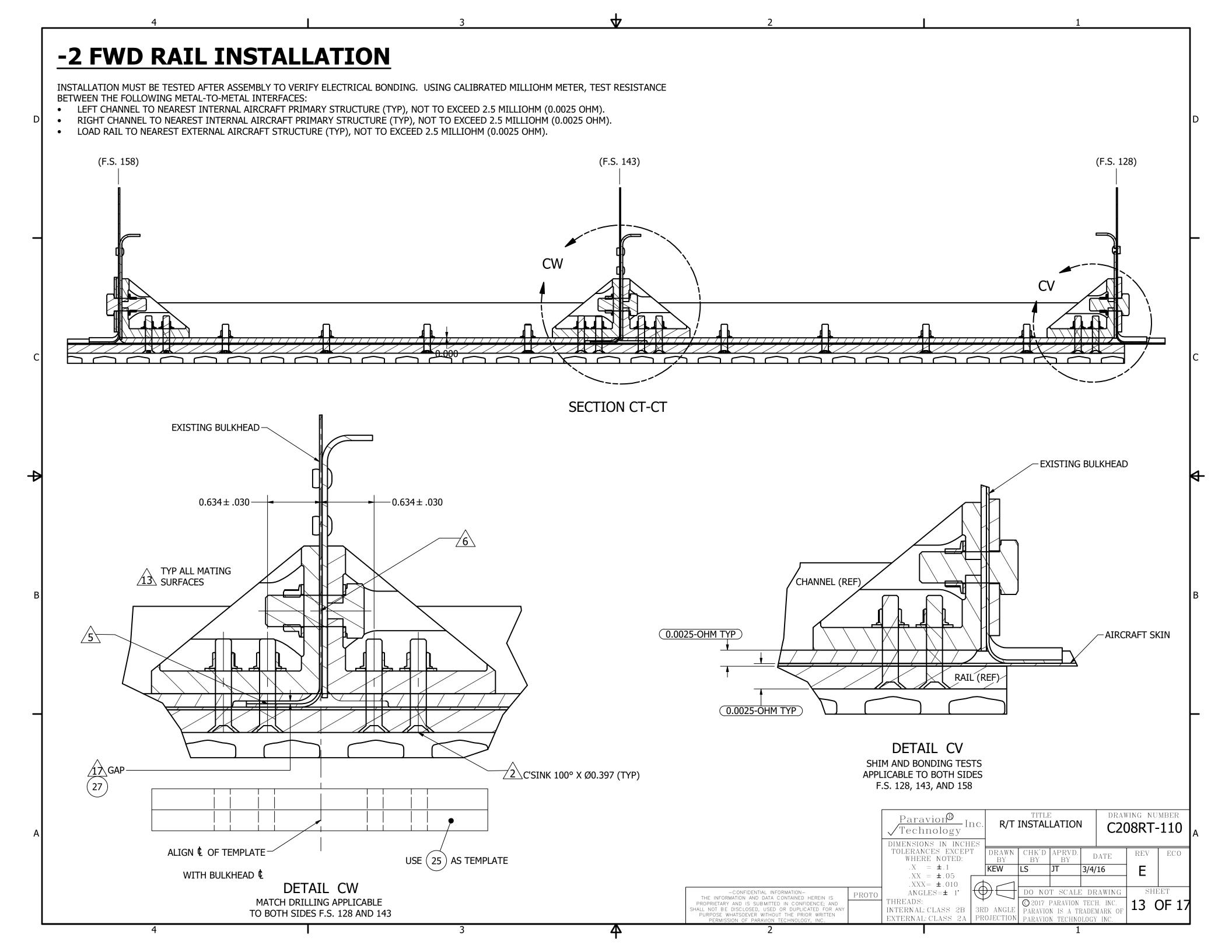


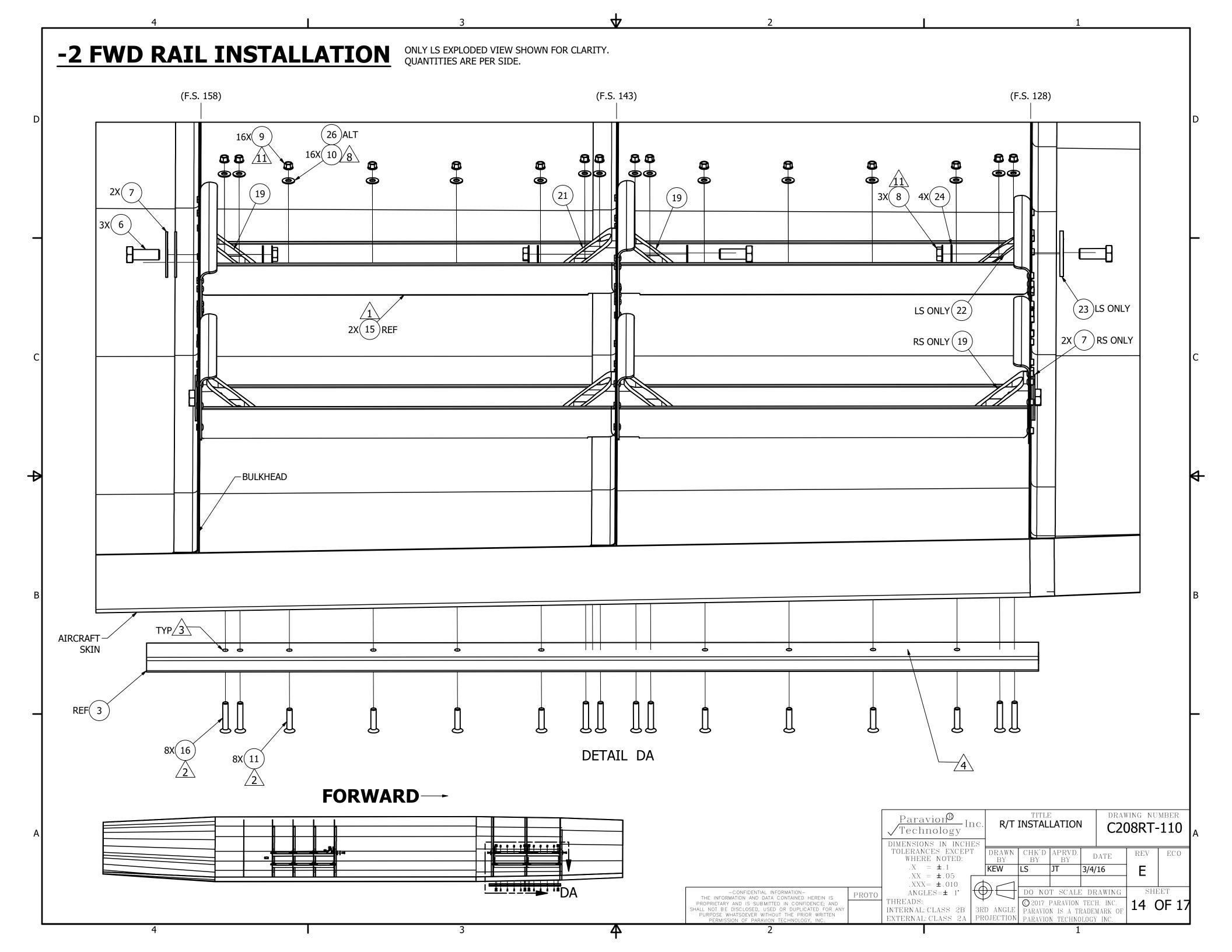


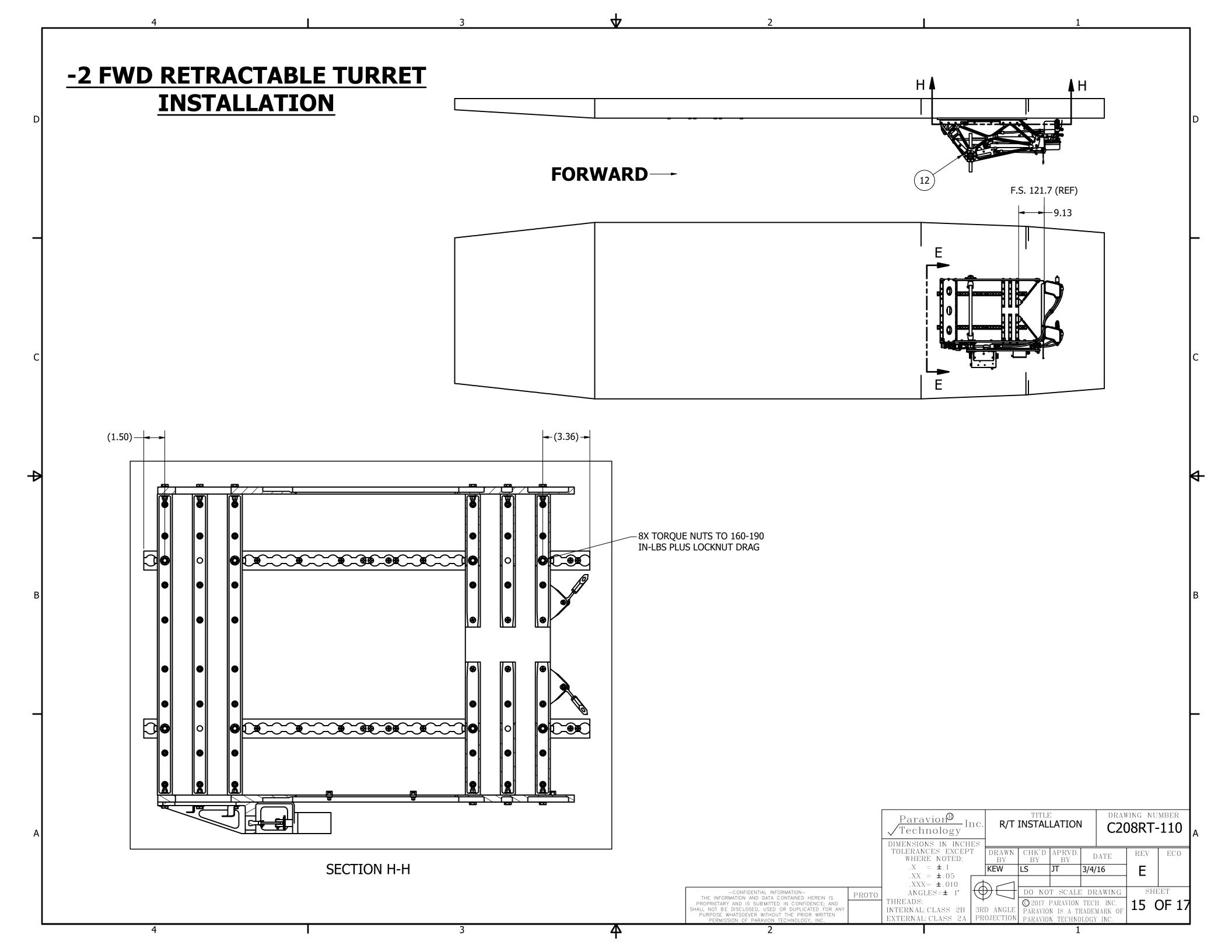


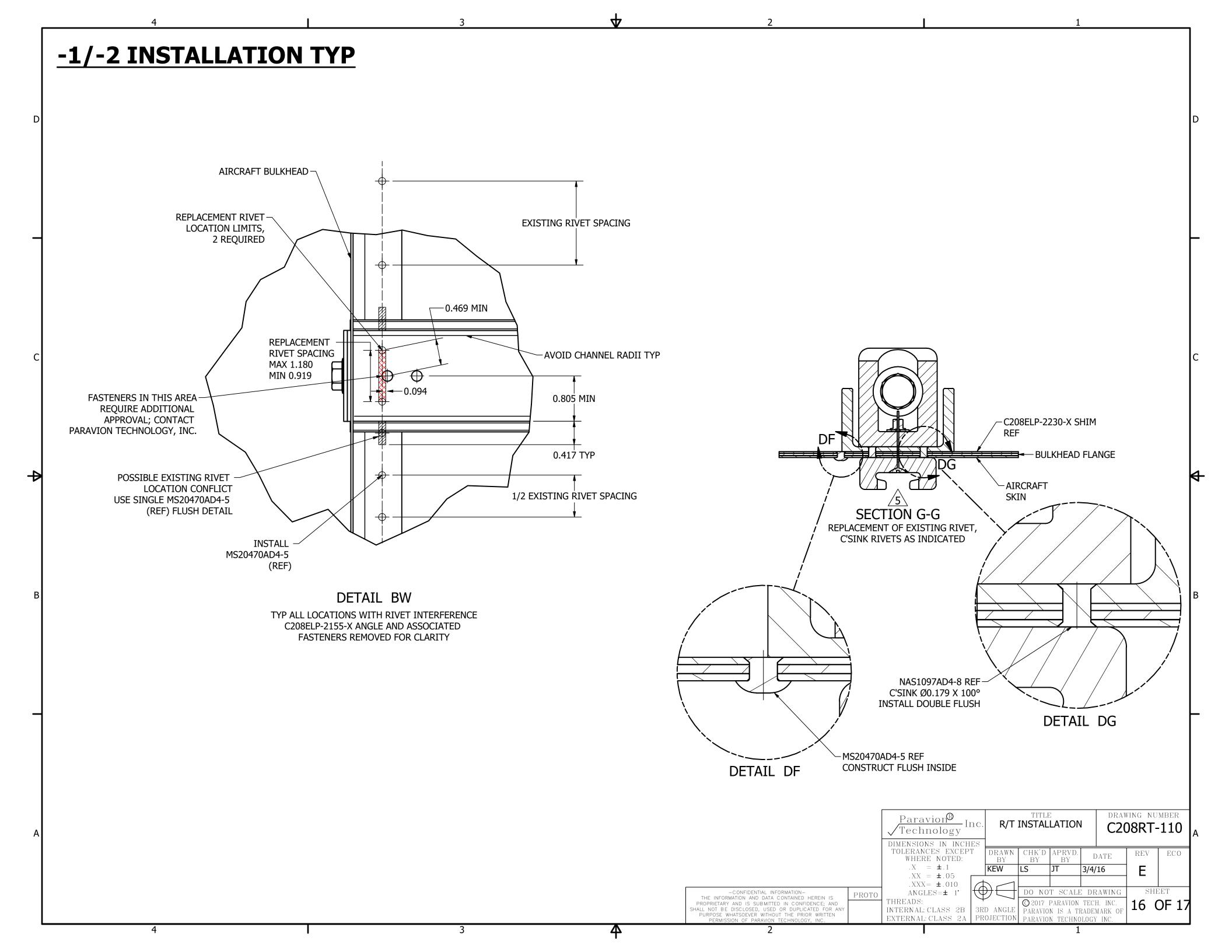


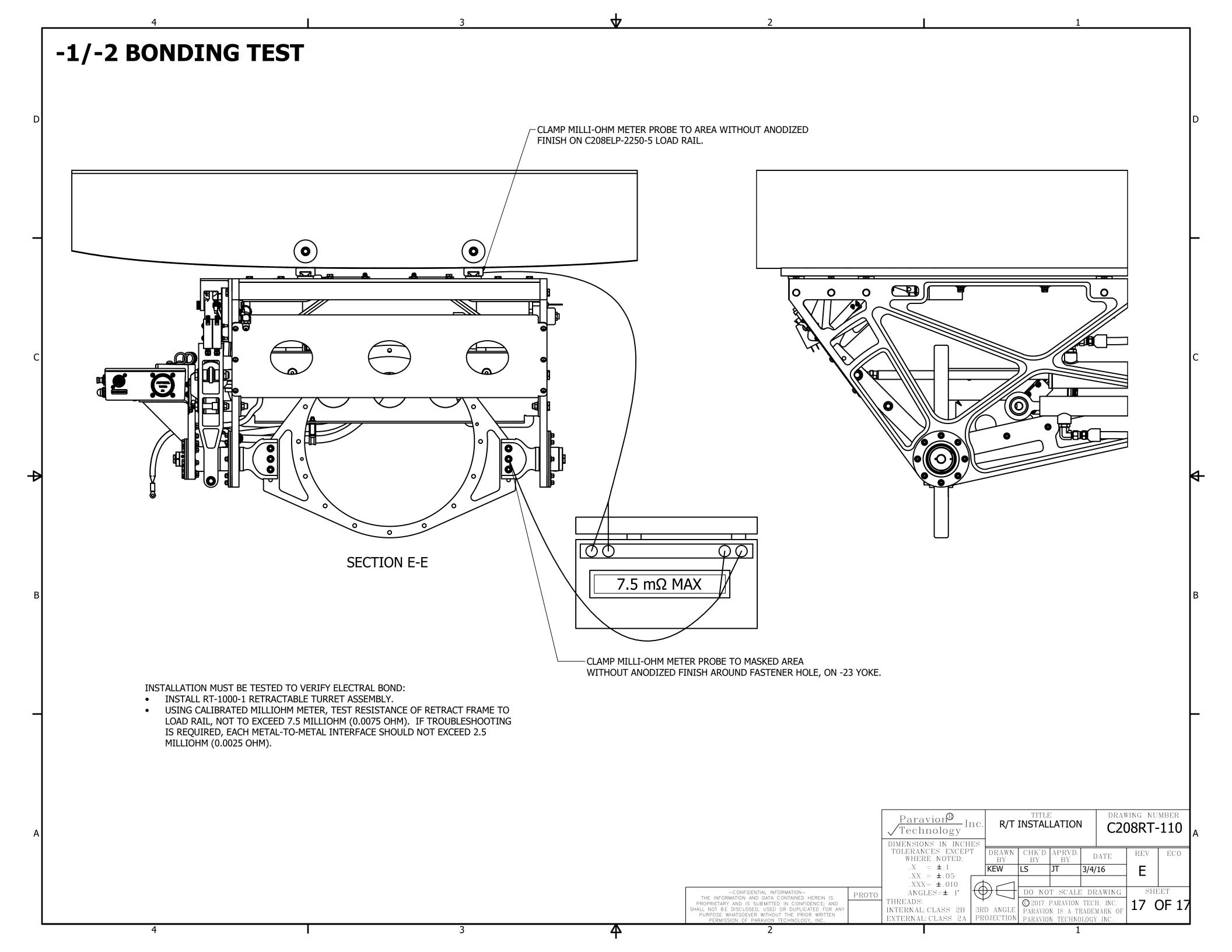












Bill of Materials

*C208RT-110-1, REV. E

ITEM #	P/N	DESCRIPTION	QTY	TYP
0	*C208RT-110-1, REV. E	R/T INSTALLATION	1	KIT
2	C208ELP-2250-5	LOAD RAIL	2	EA
4	C208ELP-2130-1	DOUBLER	1	EA
6	AN6-7A	BOLT	8	EA
7	AN970-6	WASHER	8	EA
8	MS21042L6	NUT	8	EA
9	MS21042L3	NUT	36	EA
10	NAS1149D0332J	WASHER	36	EA
11	NAS1580C3T8	SCREW	12	EA
12	RT-1000-1	RETRACTABLE TURRET ASSEMBLY	1	EA
13	MS20470AD4-4.5	RIVET	27	EA
14	C208ELP-2130-11	DOUBLER	1	EA
16	NAS1580C3T12	SCREW	24	EA
17	C208ELP-2150-13	CHANNEL	6	EA
19	C208ELP-2155-21	ANGLE	8	EA
21	C208ELP-2155-22	ANGLE	4	EA
24	NAS1149D0632J	WASHER	12	EA
25	C208ELP-T2250-1	RAIL ASSY TEMPLATE	1	EA
26	NAS1149D0363J	WASHER	36	EA
27	C208ELP-2230-1	SHIM	1	EA

Bill of Materials

*C208RT-110-2, REV. E

ITEM #	P/N	DESCRIPTION	QTY	TYP
0	*C208RT-110-2, REV. E	R/T INSTALLATION	1	KIT
3	C208ELP-2250-6	LOAD RAIL	2	EA
4	C208ELP-2130-1	DOUBLER	2	EA
5	C208ELP-2130-2	DOUBLER	2	EA
6	AN6-7A	BOLT	6	EA
7	AN970-6	WASHER	6	EA
8	MS21042L6	NUT	6	EA
9	MS21042L3	NUT	32	EA
10	NAS1149D0332J	WASHER	32	EA
11	NAS1580C3T8	SCREW	16	EA
12	RT-1000-1	RETRACTABLE TURRET ASSEMBLY	1	EA
13	MS20470AD4-4.5	RIVET	68	EA
15	C208ELP-2150-15	CHANNEL	4	EA
16	NAS1580C3T12	SCREW	16	EA
18	C208ELP-2130-12	DOUBLER	1	EA
19	C208ELP-2155-21	ANGLE	5	EA
20	C208ELP-2130-13	DOUBLER	1	EA
20	C208ELP-2130-2	DOUBLER	1	EA
21	C208ELP-2155-22	ANGLE	2	EA
22	C208ELP-2155-23	ANGLE	1	EA
23	C208ELP-2130-21	WASHER	1	EA
24	NAS1149D0632J	WASHER	8	EA
25	C208ELP-T2250-1	RAIL ASSY TEMPLATE	1	EA
26	NAS1149D0363J	WASHER	32	EA
27	C208ELP-2230-1	SHIM	1	EA